

Work Order ID 66470

Tuesday, February 15, 2011 11:40:42 AM



Page 1

Item ID: D4294-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Fitting

Start Date: 2/16/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 2/22/2011 Req'd Qty: 4.00

Customer:

Reference:

11.02.15

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4294

C

100

0.00



BAND SAW

0.00

Bandsaw

Memo

Jeaspa Bandsaw

Cut Blank to 7.125"

Batch: *1111930*

****GRAIN ALONG 4"*****

0.00

110



HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

HAAS CNC vertical machine #1

1-Machine per folio FB008

DWG REV: *C*

FOLIO REV: *AA*

2- deburr rough edges

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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

amb 11/02/23

4

0



QC

Memo

0.00

Quality Control

121

0.00

amb 11/02/23

4

0



Mill Conv

Memo

0.00

Conventional Milling Machine

DRILL & TAP FOR HELICOIL AS PER DWG

122

QC2- Inspect parts off machine FAI/FAIB

0.00

amb 11/02/23

4

0



QC

Memo

0.00

Quality Control

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Page 3

Item ID:	D4294-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Fitting					
Start Date:	2/16/2011	Start Qty: 4.00		Cust Item ID:		
Required Date:	2/22/2011	Req'd Qty: 4.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		BA 11/02/24		4	0		
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				4	0	11/02/24	
145 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M115951 MASK THREADED HOLE	0.00 0.00		7:55 3:20 8:25		4		11-2-08.	

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Page 4

Item ID: D4294-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Fitting

Start Date: 2/16/2011 Start Qty: 4.00

Cust Item ID:

Required Date: 2/22/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

⇒ m-k 11/02/28

151

Memo

0.00



Small Fab

INSTALL HELICOIL AS PER DWG

0.00

Small Fab

ES 11/02/28

152

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/11/28

Work Order ID 66470

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Page 5

Item ID: D4294-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Fitting

Start Date: 2/16/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 2/22/2011 Req'd Qty: 4.00

Customer:

Reference:

11-02-15

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

Identify as per dwg & Stock Location: *YH*

0.00



Packaging

Memo

0.00

Packaging

11/03/01 4

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*11/03/01**CL 11/03/01*

Picklist Print

Tuesday, February 15, 2011 11:40:39 AM

Page 1

Work Order ID: 66470

Parent Item: D4294-1

Parent Item Name: Fitting



Start Date: 2/16/2011

Required Date: 2/22/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 10-11-25 JLM VERIFIED BY:DD IPP REV
B: AS PER REV B 11-02-15 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21209F1-10 		Purchased	No				Each	0.0000		4			
HELI COIL M7075T73B4.000x4.00 0 		Purchased	No			100	f	8.2168	0.6	2.526316			
7075-T73 Bar 4.0 x 4.0 													

M 116977 (42)

954/02/28

Location	Loc Qty	Loc Code
MAT	8.2168	
116153	0.2578	
116324	1	
116764	6	
116867	0.959	

116930 x 2.526'

02/11/02/22

DART AEROSPACE LTD		Work Order: 66476
Description: FITTING		Part Number: D4294-1
Inspection Dwg: D4294 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.065	± 0.010	.061	—		Vern M6-7	
.305	± 0.030 ± 0.010	.307	—		"	"
3.17	± 0.030	3.175	—		"	"
3.11	± 0.030	3.113	—		"	"
.325	± 0.010	.328	—		"	"
.780	± 0.010	.779	—		"	"
.80	± 0.030	.789	—		"	"
1.560	± 0.010	1.560	—		"	"
.500	± 0.010	.490	—		"	"
.070	± 0.010	.069	—		"	"
.39	± 0.030	.394	—		"	"
.82	± 0.030	.800	—		"	"
.500	± 0.010	.501	—		"	"
.88	± 0.030	.880	—		"	"
.764	± 0.010	.764	—		"	"
Ø.20	± 0.005 ± 0.001	Ø.202	—		"	"
Ø.320 X 100°	± 0.006 X $\pm 1/2^\circ$ ± 0.001 X $\pm 1/2^\circ$	Ø.322 X 100°	—		"	"
3.44	± 0.030	3.444	—		"	"
2.450	± 0.010	2.450	—		"	"
2.04	± 0.030	2.055	—		"	"
1.528	± 0.010	1.533	—		"	"
.300	± 0.010	.306	—		"	"
.738	± 0.010	.738	—		"	"

Measured by:	anf
Date:	11/02/23

Audited by:	B.A
Date:	11/02/24

Preliminary Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

DART AEROSPACE LTD		Work Order:	66470
Description: FITTING		Part Number:	D4294-1
Inspection Dwg: D4294 Rev: C		Page 1 of 1	

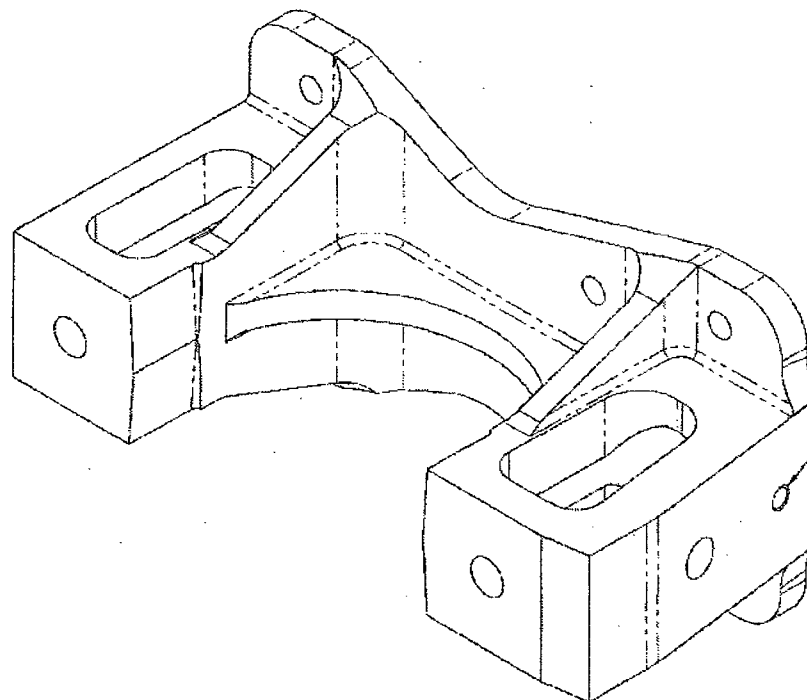
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.25	$\pm .030$.247	—		Vern	ML-7
3.375	$\pm .030$	3.375	—		"	"
4.875	$\pm .010$	4.875	—		"	"
1.670	$\pm .010$	1.670	—		"	"
Ø.386	$\pm .006$	Ø.386	—		"	"
Ø.266	$\pm .006$	Ø.271	—		"	"
6.81	$\pm .030$	6.812	—		"	CNL-02
6.35	$\pm .030$	6.350	—		"	"
3.440	$\pm .010$	3.441	—		Vern	ML-7
1.46	$\pm .030$	1.458	—		"	"
4.968	$\pm .010$	4.968	—		"	"
Ø.875	$\pm .010$	Ø.878	—		"	"
Ø.750	$\pm .010$	Ø.758	—		"	"
.332	$\pm .020$.334	—		"	"
.691	$\pm .010$.691	—		"	"
8°	$\pm 1/2^\circ$	8°	—		C-square	ML-CDB
1.405	$\pm .010$	1.410	—		Vern	ML-7
Ø.381	$\pm .006$	Ø.381	—		Micr	ML-01
1.125	$\pm .010$	1.122	—		Vern	ML-7
6.49	$\pm .030$	6.490	—		Vern	CNL-02
R.13	$\pm .030$	R.125	—		Rad-gage	REF
.64	$\pm .030$.635	—		Vern	ML-7
2.15	$\pm .030$	2.155	—		"	"

Measured by:	AMF	Audited by:	A.A	Preliminary Approval:	
Date:	11/02/23	Date:	11/02/24	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15



W/O 66470

MS21209F1-10 HELICAL COIL, 1X
REF

GRAIN
DIRECTION

D4294-1 FITTING

RELEASED
2011-02-01

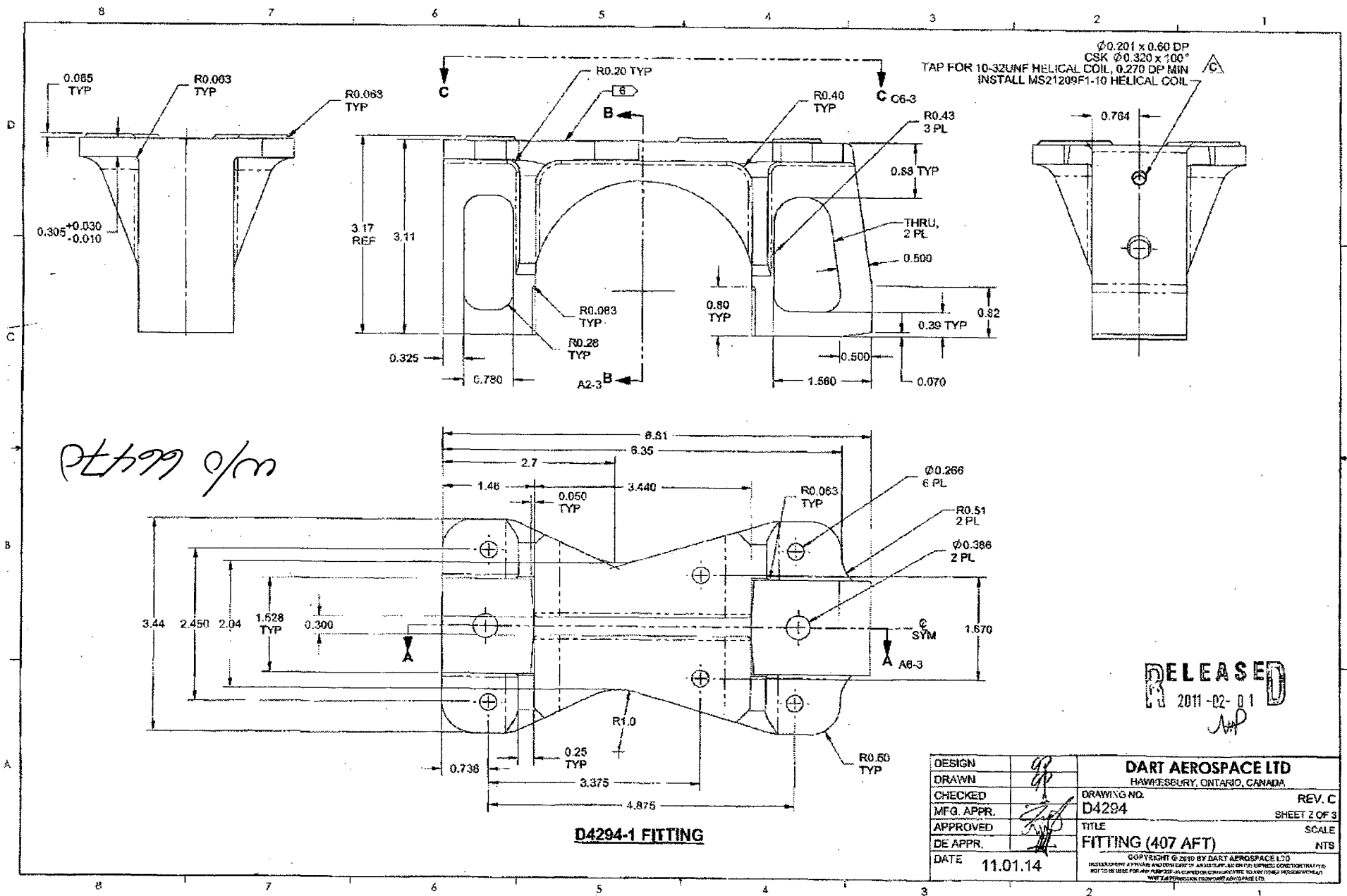
NOTES:

- 1) MATERIAL: 7075-T73/-T7351/-T73510/-T73511 BAR
PER AMS-QQ-A-200/11 OR AMS-QQ-A-225/9 (AMS 4124) OR AMS-QQ-A-250/12 (AMS 4078)
REF DART SPEC. M7075T73B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N "D4294-1" AND B/N PER DART QSI 044 6.1
- 7) WEIGHT: 1.55 lbs

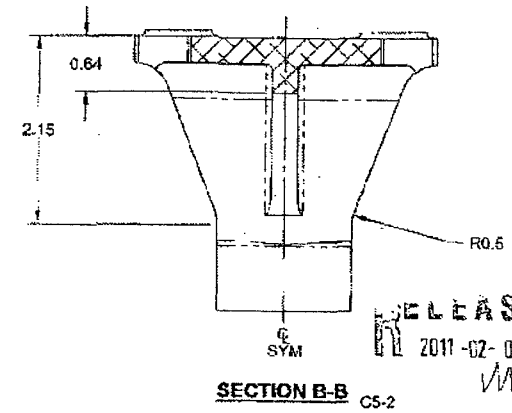
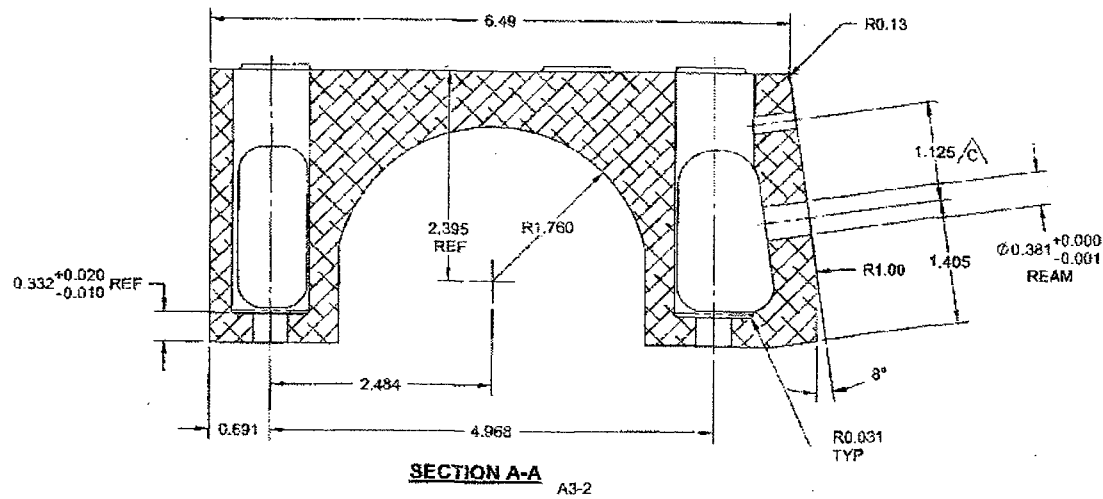
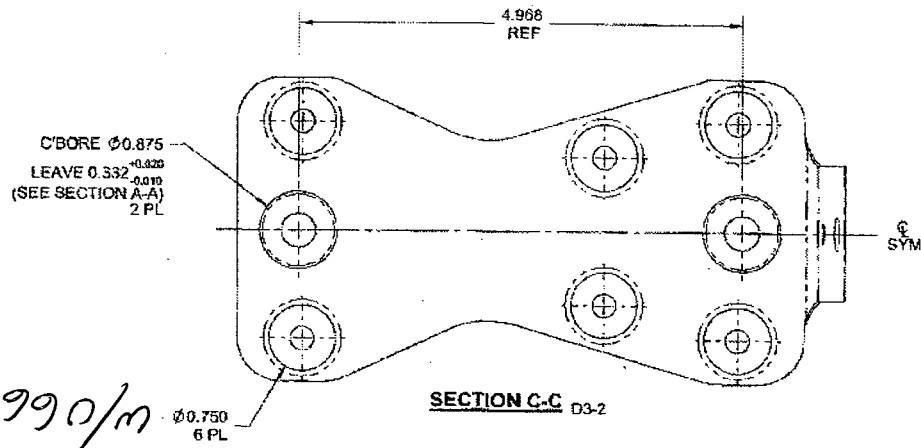
C	ADD HELICAL COIL (U1-2, B+3)	CP	11.01.14
B	0.780 WAS 0.78 (C6-2), 1.550 WAS 1.54 (C4-2)	CP	10.11.50
A	NEW ISSUE	CP	10.11.00
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.01.14		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4294	REV. C
TITLE FITTING (407 AFT)	SHEET 1 OF 3
SCALE N/A	NTS

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0.7990/m



RELEASED
2011-02-01

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4294	REV. C
MFG. APPR.		TITLE	SHEET 3 OF 3
APPROVED		FITTING (407 AFT)	SCALE
DE APPR.			NTS
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